

Date: Wednesday, 3/14/2007 3:33:22 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : X-BOLT SPACER
Job Number : 31234	
Estimate Number : 12468	
P.O. Number : N/A	Part Number : D35041
This Issue : 3/14/2007 S.O. No. : N/A	Drawing Number : D3504 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 3/14/2007 Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 31230	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 3/21/2007
Checked & Approved By : <u>[Signature]</u> 07.03.15	Qty : 50 Um : Each
Comment : Est Rev:A New Issue 06-06-20 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T0500W049	6061-T6 Tube .500 x.049W
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Comment: Qty.: 0.2972 f(s)/Unit Total : 7.4288 f(s)
 6061-T6 Tube .500 x.049W
 (M6061T6T500W049)
 Batch: M 103763

J.F. 07/03/22

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
 1-TURN AS PER FOLIO FA642 & DWG D3504,
 FOLIO REV: [Signature] } New
 DWG REV: [Signature] } prog.

2-DEBURR AS REQUIRED

J.F. 07/03/22

(50)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/03/22

(50)

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

J.L. 07/03/22

(50)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: _____

J.F. 07/03/22

J.F.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/03/26

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-BOLT SPACER

Job Number: 31234

Part Number: D35041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



52

Comment: FINAL INSPECTION/W/O RELEASE

207/03/26

Job Completion



U 07-03-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

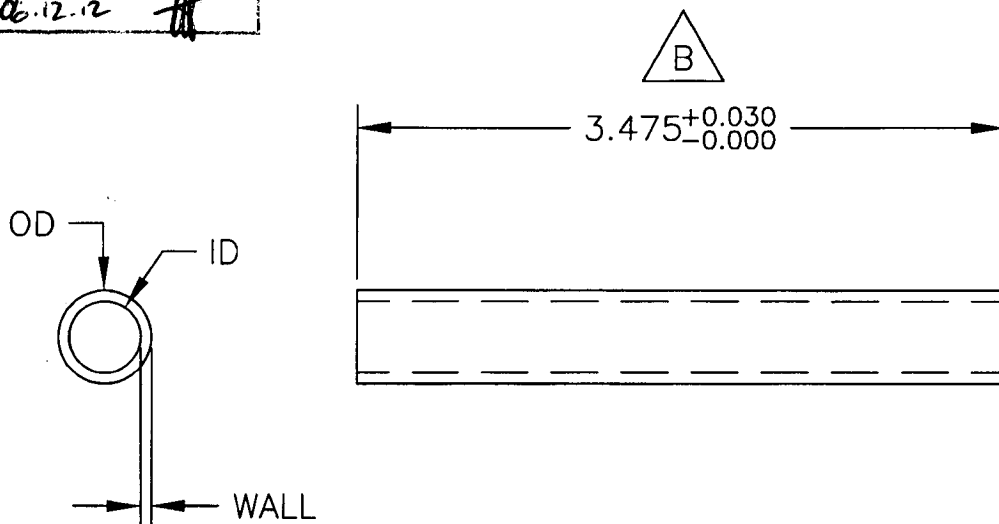
NOTE: Date & initial all entries



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3504	REV. B SHEET 1 OF 1
DATE 06.11.01		TITLE CROSS BOLT SPACER	SCALE 1:1
A	06.04.21	NEW ISSUE	
B	06.11.01	3.475 WAS 3.400	

RELEASED

06.12.12 *[Signature]*



D3504-1/-3 CROSS BOLT SPACER PARTS LIST

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3504-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3504-3	0.375	0.049	0.277	M6061T6T0.375W.049

D3504-1/-3 CROSS BOLT SPACER

- 1) MATERIAL: 6061-T6 TUBING PER WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHORT COPY
RETURN TO
ENGINEERING
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WITHOUT NOTICE
WORK ORDER
NO. *31234*

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